



**Fiberglass Services,  
Inc.**

5612 C Lawton Dr.  
Sarasota, FL 34233

Phone: (941) 923-8112  
Fax: (941) 923-2133  
e-mail:  
information  
@fiberglassservices.com

- ◆ Epoxy
- ◆ Resin
- ◆ Gel Coat
- ◆ Mat
- ◆ Woven Roving
- ◆ Cloth & Tape
- ◆ Biaxial
- ◆ Coring Material
- ◆ Polyurethane Foam
- ◆ Aerosil
- ◆ Talc
- ◆ Pigments
- ◆ Webbing Solution
- ◆ Styrene
- ◆ Acetone
- ◆ Brushes/Rollers
- ◆ Tools

**DURATEC SURFACING PRIMER**

The ultimate high-gloss surface primer for wood, MDF, foam and composite plugs, patterns and models. For composite plugs and patterns and to prime a growing number of wood products, including furniture, musical instruments and architectural applications. All in one coat! Duratec Polyester Surfacing Primer provides rapid coat buildup and a smooth surface with high gloss, when required.

Here's why you should choose Duratec Polyester Surfacing Primer:

- ◆ Low porosity-provides a super fine leveling and filling system on a variety of substrates with superior release properties.
- ◆ Adhesion to most epoxies-with heat distortion level of 201°F, the primer also adheres to fiberglass, properly prepared metal, wood, MDF, brick, concrete and polyurethane foam.
- ◆ Rapid coat build-up-to 40 mils, 1000 microns, wet on wet, on composite plugs and master mold surfaces; saves time and labor cost.
- ◆ Easy sanding-also saves time and labor. The primer cures to a surface that polishes to a high gloss, when required.

**Application Guide for Duratec Surfacing Primer**

**PLUG SURFACING**

- 1) Surface should be clean, dry and free from grease or wax. The ambient temperature should be above 60°F, for a good adhesion and product cure. Starting from a correctly-shaped and dimensionally stable plug, sand the entire surface with a coarse sandpaper (60-120 grit) making sure to feather in puttied and filled areas. Wipe the sanded surface with a fast solvent and a clean white cloth or paper towel. DO NOT USE A TACK RAG.
- 2) Thoroughly stir the DURATEC SURFACING PRIMER in the can and thin (10-40%) if necessary to a desired spray viscosity with mek solvent or a fast acrylic lacquer thinner. Catalyze at two percent (2%) with mek-p catalyst, approximately 20 cc per quart. Due o the rapid gel time of the product, mix only what can be sprayed with in 15-20 minutes.
- 3) Apply a "tack coat" to the entire surface and allow it to flash for 2 minutes. Follow with wet passes, slowly building to the desired thickness (10-40 mils) Heavier thicknesses can be achieved by repeating the process immediately after gel has occurred. The DURATEC SURFACING PRIMER will be dry to the touch in 1-4 hours, depending upon the thickness and temperature, and ready to sand within 2-4 hours.

**NOTE:** Spray pressures should be 35-50 psi. If a pressure pot is used, provide 10-15 psi pot pressure.

- 4) Dry sand the entire surface with 80-120 grit sandpaper. Wipe the surface with a fast solvent and a clean white cloth or paper towel. DO NOT USE A TACK RAG.
- 5) Spray the primer as in Steps 2-3. If an even higher gloss is desired, blend the Primer 1:1 with the DURATEC HI-GLOSS ADDITIVE, thin with a fast acrylic-thinner or mek solvent and spray to the desired thickness following the equipment directions as described in the NOTE of Step 3. Sand to a 600 or higher grit finish.

To achieve the ultimate gloss, spray a topcoat of the DURATEC BLACK HI-GLOSS COATING over the sanded DURATEC SURFACING OR SANDING PRIMER (thin with a fast acrylic lacquer thinner or mek solvent if desired) and when cured, sand to a 600 or higher grit finish.

**NOTE:** To achieve the highest possible gloss: after sanding, wait overnight prior to compounding, polishing and prep-ping the surface.

- 6) Remove the scratches with AQUA-BUFF 1000 FAST CUT COMPOUND and polish with AQUA-BUFF 2000 COMPOUND/POLISH for a glossy, swirl mark-free finish. No surface cleaning is necessary prior to the application of release materials.

<b>PRODUCT PROPERTIES</b> -All time calculations are based on temperatures of 77°F, 25°C
Viscosity-as measured on a Brookfield Viscometer Model RVF, spindle #5 at 2.5 rpm- <b>2700 cps</b>
Thixotropic Index- <b>5</b>
Gel Time-Sample based on a 100 g mass, catalyzed at 2% with mekP- <b>16-18 minutes</b>
Weight per gallon- <b>10.90 lbs, 4.95 kg.</b>
Volatile Organic Compounds - <b>199 g/L</b>
Coverage per gallon- <b>110-115 sq. ft.</b>